

Date: Thursday, 12/20/2007 3:19:15 PM  
 User: Kim Johnston

## Process Sheet

4

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY  
 Job Number : 36476A  
 Estimate Number : 10023  
 P.O. Number :  
 This Issue : 12/20/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : LANDING GEAR  
 Previous Run : 36475A  
 Written By :  
 Checked & Approved By : 107.12.21  
 Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 Est Rev. O 06.02.28 Added paperwork EC  
 Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Part Number : D205634041  
 Drawing Number : D2580 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 Material :  
 Due Date : 1/20/2008 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 08-01.21

Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634 CHG002

2.0 D25001190 Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total: 1.0400 Each(s)

Pick:

Qty Part Number Description Batch

1 D2500-1-190 Skid Tube Extrusion B34729

a.m 08.01.07 (1)

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2596 205 Web

B36518

a.m 08.01.08 (1)

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage a.m 08.01.07 (1)

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

a.m 08.01.07 (1)

3-Acid etch and Alodine tube per QSI 005 4.1

a.m 08.01.07 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BB 08/01/08

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

a.m 08.01.08 ①

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

a.m 08.01.08 ①

3-Countersink holes as per Dwg D2580without cutting fluid

a.m 08.01.08 ①

4-Deburr and blow out all chips from inside of tube

a.m 08.01.08 ①

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M105488

Sikaflex expire date: 01.08

Start Time: 1:30 Date: 08.01.08

Fin Time: 8:45 Date: 8-1-16

a.m 08.01.08 ①

7.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL/ID 8-1-16

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

7 SL 8-1-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36476A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 08/01/16*

10.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2576-3

Step

*B-33464 BE 08/01/16*

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

20

D2579

Spacers

*B-34789 BE 08/01/16*

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

*m106390 BE 08/01/16*

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

*m106390 BE 08/01/16*

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

*a.m 08.01.17*

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

*a.m 08.01.17*

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

*a.m 08.01.17*

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

*a.m 08.01.17*

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

*a.m 08.01.17*

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36476A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08/02/11 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/21 (4)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

08-01-29 (x1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 106379

BR 08-01-30

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M- 08/01/30 (1X)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B35972

M- 08/01/30

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M 100188

M- 08/01/30

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch:

M 104885

M- 08/01/30 (1X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ P&R #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36476A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

ALS71032130

Insert



ALS41032130 min 2008/2/05



✱

Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Insert

Batch:

M105729

m. d.

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

BOLT

Batch:

M106883

m. d.

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

washer

Batch:

M106552

m. d.

24.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B32744

m. d.

25.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch:

B36113

m. d.

26.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch:

B36112

m. d.

27.0

D356413

WEARSHOE



(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch:

B33867

m. d.

08/01/30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36476A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B 34805

M. J.

29.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B 36023

M. J.

30.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B 36338

M. J.

31.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch:

B 27168

M. J.

32.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch:

B 33450

M. J.

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date:

M 105585  
08/07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg. D2580

3-Inspect for foreign object per QSI 024

M. J.  
08/01/30

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/02/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number: 36476A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M105585

08/07

M-1 08/01/31

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: m106332

F-2 08/01/31 ①

34.0

QC5

INSPECT WORK TO CURRENT STEP



08/01/31 ①



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

36476A H

8/24/05

1/8/45

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
08/02/06

Job Completion



m 2008/2/05 ①

<b>DART</b>		TEL: 1-613-632-3336 FAX: 1-613-632-4448	
TRANSPORT CANADA APPROVAL # 09-89			
PIN	D205-634-011	CHG	CHG005
DESC	Skidtube	STC	SH96-88
LOT	B36476	STC	SR00563NY
MODEL	Bell 205/210/212/214/412	STC	
MADE IN CANADA			
US PATENT # 5,735,484 CANADA FOREIGN PATENTS PENDING			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY RH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED  
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

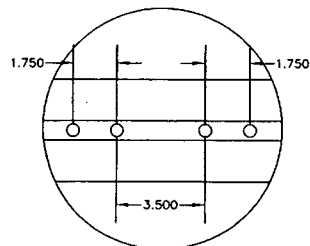
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36476A

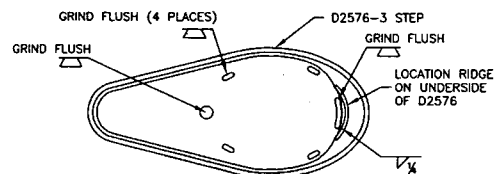
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**DETAIL A**  
SCALE 5:24

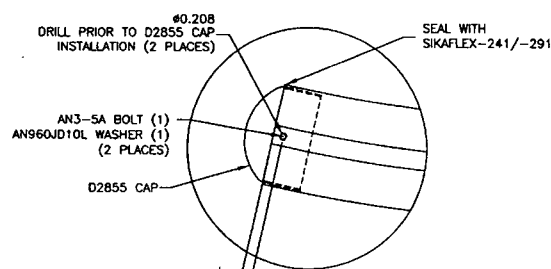


**DETAIL B**  
SCALE 5:24

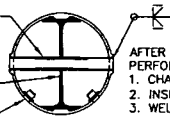


**RELEASED**  
07 Dec 84

**DETAIL C**  
SCALE 5:24

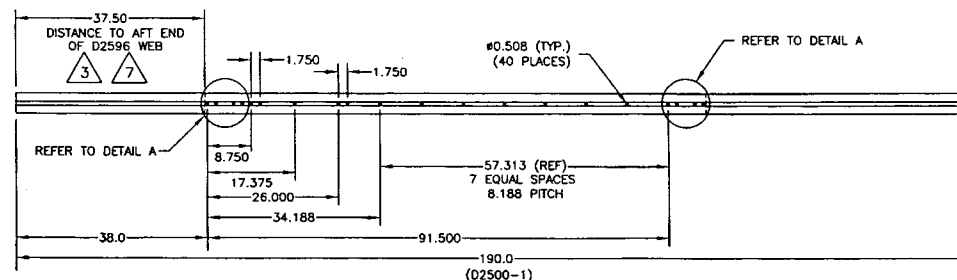


**SECTION D-D**  
SCALE 5:24

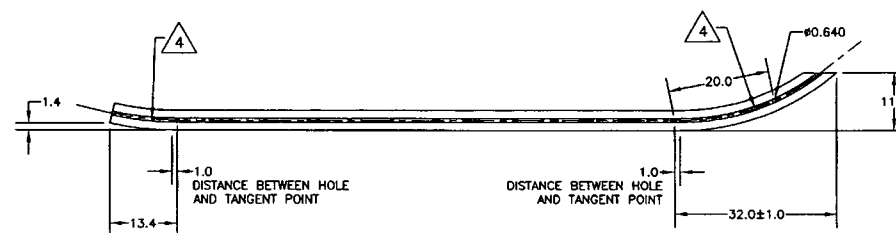


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

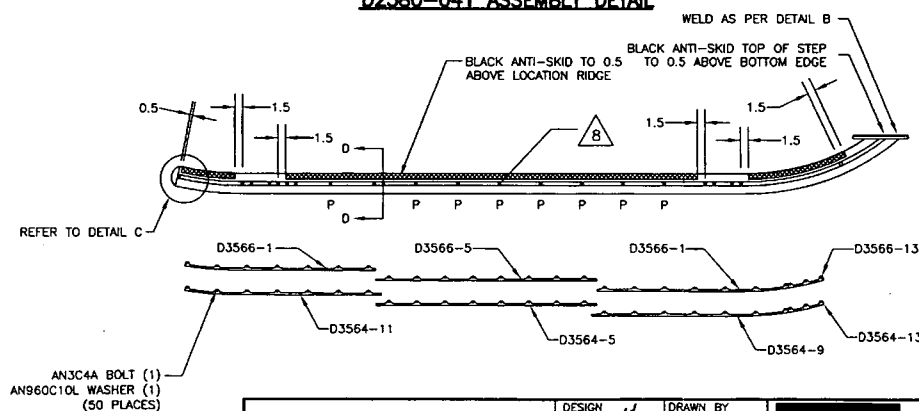
**D2580-1 DRILLING DETAIL**



**D2580-1 BENDING AND CUTTING DETAIL**



**D2580-041 ASSEMBLY DETAIL**



**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

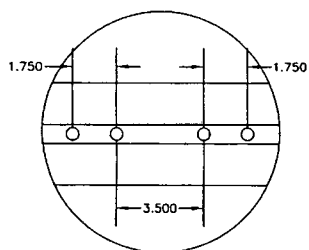
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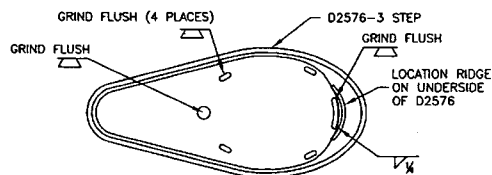
DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24



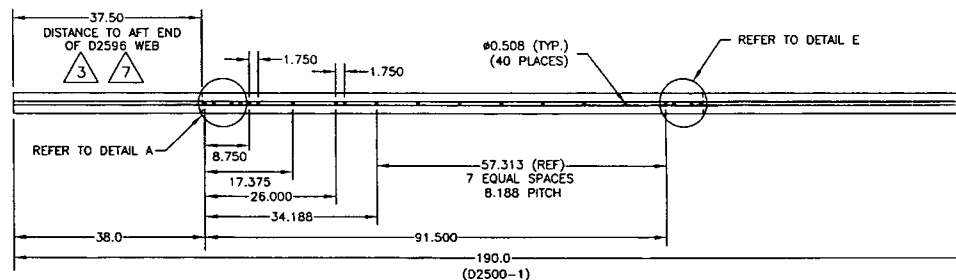
**DETAIL E**  
SCALE 5:24



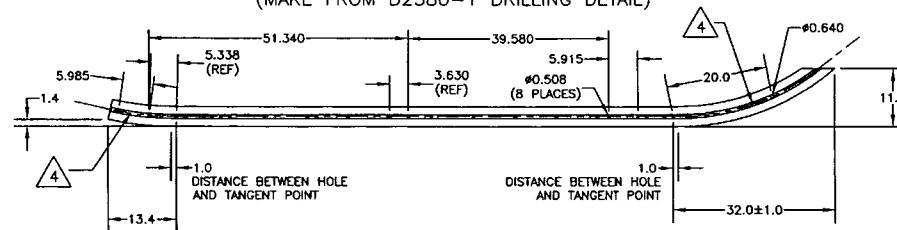
**DETAIL F**  
SCALE 5:24



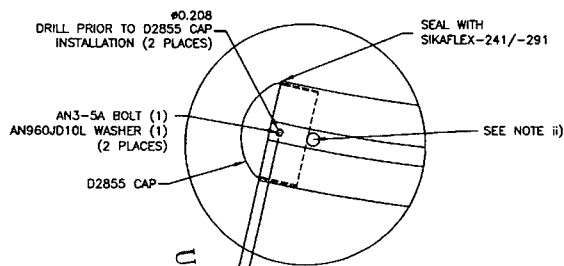
**D2580-1 DRILLING DETAIL**



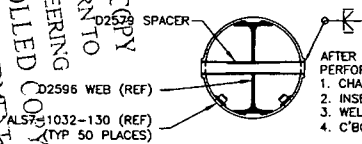
**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



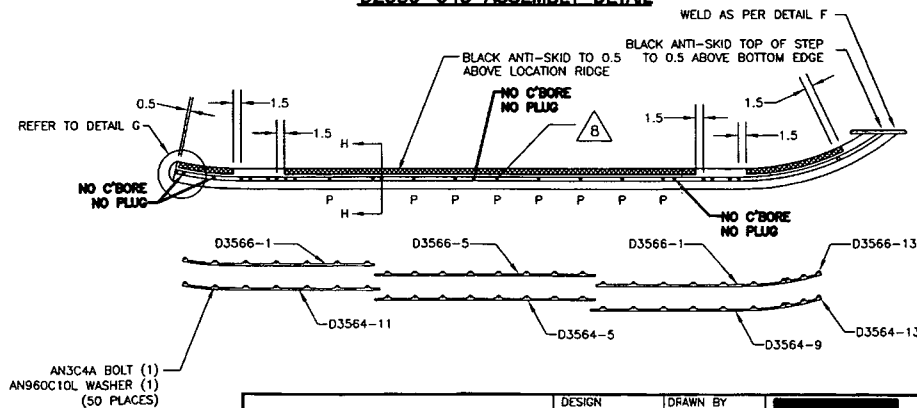
**DETAIL G**  
SCALE 5:24



**SECTION H-H**  
SCALE 5:24



**D2580-045 ASSEMBLY DETAIL**



**D2580-045 NOTES**

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. 0
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SHEET 3 OF 3	SCALE 1:24

NO. 139

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barday E.  
Joint Welding Procedure GTAW  
Part number and Job number D205 624 041 / B36286

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS TIG  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input checked="" type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Ski tube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-01-07

Qualifier Pat. Duml

4

Date: Thursday, 12/20/2007 3:18:51 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY  
 Job Number : 36476  
 Estimate Number : 10022  
 P.O. Number :  
 This Issue : 12/20/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : LANDING GEAR  
 Previous Run : 36475  
 Part Number : D205634011  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material :  
 Due Date : 1/20/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 12/21  
 Comment : Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ

## Additional Product

Job Number:



*close all only*

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG005

2.0 36476A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B *36476A*

*56*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit

*1556307*

*8/2/4 500 (1x)*

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: *d*

*8/2/4 500 (1x)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:18:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 36476

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*pin 2008/12/05* (6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries